

Date: Monday, 2/27/2006 4:17:55 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING ANGLE
Job Number	: 25970		
Estimate Number	: 10509		
P.O. Number	: N/A	Part Number	: D2564
This Issue	: 2/27/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2564 REV. B1
First Issue	: N/A	Project Number	: N/A
Previous Run	: N/A	Drawing Revision	: B1
	Type : MACHINED PARTS	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 3/20/2006
Checked & Approved By	: <u>06.02.28</u>	Qty:	50 Um: Each
Comment	: Est:D 02.09.09 Re-format; Added FA276 Folio KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6207	Angle Extrusion 1x1x.125
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Comment: Qty.: 0.0962 f(s)/Unit Total: 4.8090 f(s)

Angle Extrusion

Material: D6207 (1" x 1" x .125 angle) 6061-T6/T6511 (QQ-A-200/8)

(D6207)

Batch: B24248

ML 06/04/06

52

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut D6207 Extrusion: 1.00" Long (+0.000/-0.030)

ML 06/04/06

52

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA276 and Dwg D2564

Tumble and Deburr

Identify as D2564

ML 06/04/06

52

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ML 06/04/06

52

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

MS 06/04/06

52

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 00/01/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/27/2006 4:17:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING ANGLE

Job Number: 25970

Part Number: D2564

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA 3

RF 06.04.07 52

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

S 06/04/10 (52)

Job Completion



U 06.04.07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25990
Description: Mounting Angle	Part Number:	D2564
Inspection Dwg: D2564 Rev: B1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

<input checked="" type="checkbox"/> First Article	<input type="checkbox"/> Prototype
<p>1. Introduction</p> <p>2. Background</p> <p>3. Methodology</p> <p>4. Results</p> <p>5. Conclusion</p>	<p>1. Introduction</p> <p>2. Background</p> <p>3. Methodology</p> <p>4. Results</p> <p>5. Conclusion</p>

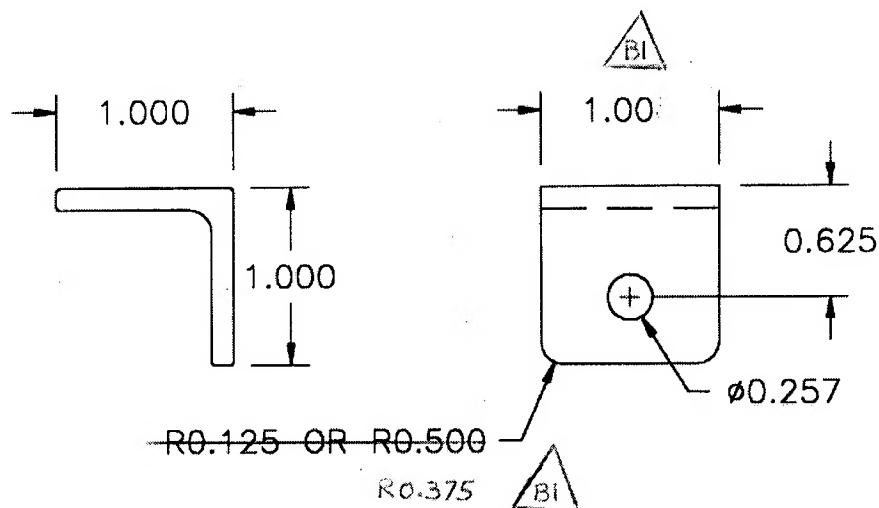
[illegible]

Measured by:	<i>mf</i>	Audited by:	<i>MS</i>	Prototype Approval:	N/A
Date:	<i>06/04/06</i>	Date:	<i>06/04/06</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.10	New Issue	KJ/JLM	

DART

DESIGN		DRAWN BY		DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
MIKE M		MIKE M		DRAWING NO. D2564	REV. B
CHECKED BW		APPROVED BW			SHEET 1 OF 1
DATE 96:04:30		TITLE MOUNTING ANGLE			SCALE 1:
B	97:05:06		MODIFIED DIMENSIONS		
BI	RF 02.09.17		R0.375 WAS R0.125 OR R0.500; 1.00 WAS 1.000		

RELEASED
97/05/06 BWNOTES:

- 1) MATERIAL: 6061-T6 ANGLE 1.0 X 1.0 X 0.125
MAKE FROM D6207-XXX ANGLE EXTRUSION
- 2) BREAK ALL SHARP EDGES 0.005 - 0.015
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25970